



S. R. Industries

STAR ARC E10018-D2

E10018-D2 is a high quality electrode used for joining high tensile steels and manganese molybdenum steels. The coating is specially formulated to resist moisture pick-up under conditions of high heat and humidity. This electrode offers resistance to moisture reabsorption which helps prevent hydrogen cracking and aids in elimination of starting porosity. E10018-D2 is specifically designed for applications requiring at least 100 ksi tensile strength, good ductility and crack resistance.

Applications :

- Manganese-Moly castings
- Alloy Forgings
- Structure and pressure vessels

AWS Specification :

- AWS A5.5/A5.5M:2006

AWS Classification :

- E10018-D2 H4R

Welding Current :

- AC - DCEP

Welding Position :

- F,V,OH,H

Typical Wire Chemistry :

- C 0.15
- Mn 1.65 - 2.00
- Si 0.80
- Mo 0.25 - 0.45
- P 0.03
- S 0.03
- Ni 0.90

Typical Mechanical Properties (As Welded) :

Yield Strength, ksi	91
Tensile Strength, ksi	100
Elongation%, min	16

Available Diameters : 3/32", 1/8", 5/32" & 3/16"

Operating Range in Amps :

3/32"	70 - 100
1/8"	115 - 155
5/32"	135 - 185

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